



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2940-1

Job Sheet 173690



Part No: D2940-1

Job Qty: 12 ea

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 4/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP C 02.11.26 Reformat; Added P/O KJ IPP Rev:D Added priming as per Rev B 07-04-30 JLM
IPP E 08.03.19 Re-format Ec verified by DD IPP Rev:F 08-10-22 add qc14 DD verified by:EC IPP Rev:G
11.08.04 as per dwg rev.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		4/13/18	0.00	0.00	Start Up Machining-1		
100	CNC Vertical Machining	12 pcs		4/14/18	0.32	28.57	HAAS1-2		
110	QC	12 pcs		4/14/18	0.00	0.00	QC2 Machining-1		
120	QC	12 pcs		4/14/18	0.00	0.00	QC8 Machining-1		
130	Crosstubes	12 pcs		4/16/18	0.00	1.50	Crosstubes-2		
140	QC	12 pcs		4/16/18	0.00	0.00	QC5		
170	Packaging	12 pcs		4/16/18	0.00	0.00	Packaging3-1		
180	QC21-SA	12 Ea		4/16/18	0.00	0.00	QC21		

Part Op 100 - 1-Machine as per Folio FA079

Descriptions: 130 - Per note 8 on page 1 of dwg D2940, Prep inner concave surface of support and apply 3M Scotch Weld as per dwg.

170 - LOCATION : L052

B# 138381 exp 11/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK081	D2940-1 Turning Detail	6 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	DSK081	6	7	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
2	3.250 Support	0.490Inches + 0.020 - 0.000	0.510 0.490		
3	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
4	3.250 Support	3.510Inches + 0.020 - 0.000	3.530 3.510		
5	3.250 Support	1.633Inches	1.673		

DART
AEROSPACE

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CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S055687



Part: D2940-1

Job No: 173690

Serial No/Batch: S055687

Revision:

Inspector:

Date: 03/27/18

			+ 0.040	1.633
			- 0.000	
6	3.250 Support	1.493Inches	+ 0.020	1.513
			- 0.000	1.493
7	3.250 Support	0.040Inches	+ 0.020	0.060
			- 0.000	0.040
8	3.250 Support	0.188Inches	+ 0.005	0.193
			- 0.000	0.188
9	3.250 Support	0.140Inches	+ 0.020	0.160
			- 0.000	0.140
10	3.250 Support	2.518Inches	+ 0.020	2.538
			- 0.000	2.518
11	3.250 Support	0.040Inches	+ 0.020	0.060
			- 0.000	0.040
12	3.250 Support	0.010Inches	+ 0.010	0.020
			- 0.000	0.010
13	3.250 Support	0.140Inches	+ 0.020	0.160
			- 0.000	0.140
14	3.250 Support	0.350Inches	+ 0.100	0.450
			- 0.000	0.350
15	3.250 Support	0.240Inches	+ 0.020	0.260
			- 0.000	0.240
16	3.250 Support	0.150Inches	+ 0.020	0.170
			- 0.000	0.150
17	3.250 Support	0.053Inches	+ 0.020	0.073
			- 0.000	0.053
18	3.250 Support	101.640Inches	+ 4.000	105.640
			- 0.000	101.640
19	3.250 Support	0.260Inches	+ 0.007	0.267
			- 0.000	0.260
20	3.250 Support	0.053Inches	+ 0.020	0.073
			- 0.000	0.053
21	3.250 Support	4.118Inches	+ 0.020	4.138
			- 0.000	4.118

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DART AEROSPACE LTD		Work Order:	
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		R.250 OK	R.250	R.250	R.250	R.250
AB	0.490	0.510		R.500 OK	R.500	R.500	R.500	R.500
AC	0.140	0.160		.158	.157	.157	.158	.157
AD	3.510	3.530		3.522	3.518	3.518	3.517	3.520
AE	1.633	1.673		1.664	1.664	1.666	1.662	1.659
AF	1.493	1.513		1.510	1.510	1.512	1.511	1.506
AG	0.040	0.060		.051	.052	.051	.050	.050
AH	0.188	0.193		.188 Ø	.188 Ø	.188 Ø	.188 Ø	.188 Ø
AI	0.140	0.160		.155	.149	.150	.150	.151
AJ	2.518	2.538		2.538	2.538	2.538	2.535	2.538
AK	0.040	0.060		.056	.049	.047	.049	.050
AL	0.010	0.020		.011	.011	.011	.011	.011
AM	0.140	0.160		.159	.155	.159	.157	.158
AN	0.350	0.450		.355	.358	.355	.355	.356
AO	0.240	0.260		R.250 x	R.250	R.250	R.250	R.250
AP	0.150	0.170		.160	.156	.157	.156	.159
AQ	0.053	0.073		R.063 OK	R.063	R.063	R.063	R.063
AR	101.64	105.64		103.5	103.50	103.50	103.50	103.50
AS	0.260	0.267		.260 Ø	.260 Ø	.260 Ø	.260 Ø	.260 Ø
AT	0.053	0.073		.063 R	R.063	R.063	R.063	R.063
AU	4.118	4.138		4.128	4.128	4.131	4.134	4.134
AV								
AW								
Accept/Reject								

Measured by:

M.M. / pmf

Date: 2018/03/27

Audited by:

H.A.

Date: 18-04-03

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

DART AEROSPACE LTD		Work Order:	
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940		Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	17	18	19	10
HAAS Section								
AA	0.240	0.260		R. 250	R. 250	0.250	0.250	0.250
AB	0.490	0.510		R. 500	R. 500	0.500	0.500	0.500
AC	0.140	0.160		.158	.156	.152	0.152	0.152
AD	3.510	3.530		3.518	3.515	3.520	3.520	3.520
AE	1.633	1.673		1.662	1.664	1.665	1.660	1.661
AF	1.493	1.513		1.506	1.510	1.510	1.509	1.510
AG	0.040	0.060		.049	.053	0.050	0.050	0.050
AH	0.188	0.193		.188 Ø	.188 Ø	0.188	0.188	0.188
AI	0.140	0.160		.153	.153	0.155	0.150	0.150
AJ	2.518	2.538		2.535	2.534	2.528	2.530	2.530
AK	0.040	0.060		.048	.049	0.050	0.050	0.050
AL	0.010	0.020		.011	.011	0.011	0.011	0.011
AM	0.140	0.160		.160	.158	0.153	0.151	0.152
AN	0.350	0.450		.350	.355	0.430	0.400	0.400
AO	0.240	0.260		R. 250	R. 250	0.250	0.250	0.250
AP	0.150	0.170		.156	.153	0.155	0.153	0.152
AQ	0.053	0.073		.063 R	.063 R	0.063	0.063	0.063
AR	101.64	105.64		103.50	103.50	103.64	103.64	103.64
AS	0.260	0.267		.260 Ø	.260 Ø	0.260	0.260	0.260
AT	0.053	0.073		.063 R	.063 R	0.063	0.063	0.063
AU	4.118	4.138		4.130	4.127	4.130	4.133	4.130
AV								
AW								
Accept/Reject								

Measured by: <u>MM</u>	Date: <u>2014/03/28</u>
Audited by: <u>B.E</u>	Date: <u>18/04/03</u>
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

DART AEROSPACE LTD		Work Order:	
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☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		0.250	0.250			
AB	0.490	0.510		0.500	0.500			
AC	0.140	0.160		0.152	0.152			
AD	3.510	3.530		3.520	3.520			
AE	1.633	1.673		1.660	1.660			
AF	1.493	1.513		1.500	1.510			
AG	0.040	0.060		0.050	0.050			
AH	0.188	0.193		0.188	0.188			
AI	0.140	0.160		0.150	0.150			
AJ	2.518	2.538		2.530	2.530			
AK	0.040	0.060		0.050	0.050			
AL	0.010	0.020		0.011	0.011			
AM	0.140	0.160		0.150	0.150			
AN	0.350	0.450		0.400	0.400			
AO	0.240	0.260		0.250	0.250			
AP	0.150	0.170		0.160	0.160			
AQ	0.053	0.073		0.063	0.063			
AR	101.64	105.64		101.64	101.64			
AS	0.260	0.267		0.260	0.260			
AT	0.053	0.073		0.063	0.063			
AU	4.118	4.138		4.128	4.128			
AV								
AW								
Accept/Reject								

Measured by: _____ **Date:** _____

Audited by: *A. M.* **Date:** *18-01-03*

Prototype Approval: _____ **Date:** _____

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
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